		ASAD Spli	f. Dart Aerospa	ace Ltd.
	sday, 25/10/2007 2:34:52 PM a Lacelle	Process Sheet		4 -4
Customer Job Number Estimate Number	: CU-DAR001 Dart Helicopters Services : 35400 - (: 11155	Drawing Name	: SHAFT SLEEVE	4
P.O. Number This Issue Prsht Rev. First Issue	: NA : 25/10/2007 S.O. No. : NO : NC : NA Type : MACHINED		: D32337 : D3233 REV B : N/A : B	
Previous Run Written By Checked & Approv Comment	: 28618 ved By : Est. A 05.03.14 New issue	Material Due Date KJ/JLM	: MA : 01/11/2007	14 Um: Each
Additional Produc	t			
Job Number:				
Seq. #:	Machine Or Operation:	Description :		
1.0	M1020TR1375W125	COLD DRAWN ROUND TUBE		
1 7 10				
Comm	ent: Qty.: 0.1860 f(s)/Unit Total: 1020-1025 Round Tube Material: AISI 1020-1025 Seamless I SRA or AMS 5075 or AMS 5077 (M1020TR1.375W.125) Identify for D3233-7 Batch: 103258	2.6034 f(s) Round Tubing Cold Drawn per MIL-T	7-5066 or ASTM A513-00 MT10	20 107-11-17.
2.0	LATHE CONV.	CONVENTIONAL LATHE		
Comm	ent: CONV.LATHE Turn as per Dwg D3233		4	1/07.11.20
3.0	QC2	INSPECT PARTS AS THEY COME	E OFF MACHINE	11
4.0	ent: INSPECT PARTS AS THEY COME (SECOND CHECK		-prof 07-11-2
		SECOND CRECK		
	ent: SECOND CHECK	CONVENTIONAL MILLING MACH	INIE	oZalireo
5.0	MILLING CONV.	CONVENTIONAL MILLING MACH		

Comment: CONVENTIONAL MILLING MACHINE

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Dait	MOI	U O I	Jac		L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				1	_	1	X X

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: Mulac
			QA: N/C Closed: _	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)										
Mari Marie Carlossof				Description of NC		Corrective Action Section B		Verification	Approval	Anneousl
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
							-			

NOTE: Date & initial all entries

Thursday, 25/10/2007 2:34:52 PM User: Linda Lacelle **Process Sheet** Drawing Name: SHAFT SLEEVE Customer: CU-DAR001 Dart Helicopters Services Job Number: 35400 Part Number: D32337 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 CARL Comment: PACKAGING RESOURCE #1 Identify and Stock Location: W523 QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE le Stelle 20 Job Completion

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W/O:			WORK ORD	ER CHANGE	ES				
DATE	STEP	PROC	EDURE CHANGE	f	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					8				
Part No	:	PAR #:	_ Fault Category:		NCR: Yes	No DQ	A:	Date:	

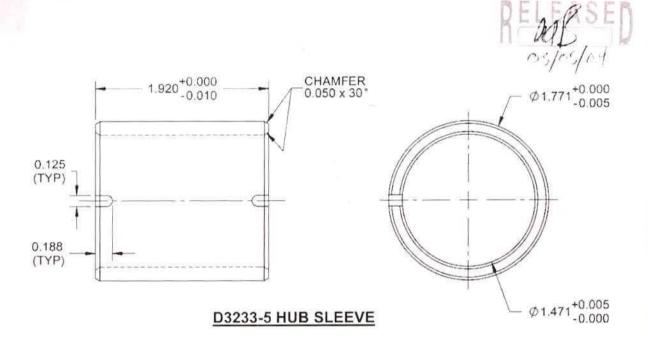
QA: N/C Closed: ____ Date: ___

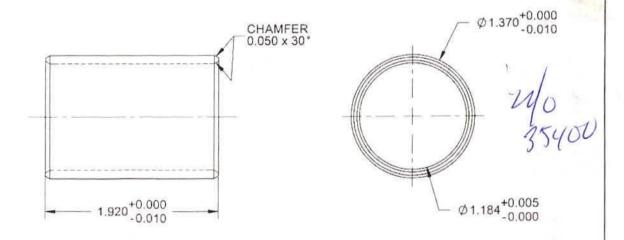
	VVC	JKK OKD	ER NON-CONFORMANO	E (NCR)			
	Description of NC	Corrective Action Section B		Varification	Annes		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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	STEP	STEP Description of NC Section A	Section A Initial	STEP Section A Initial Action Description	STEP Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Section A Initial Action Description Sign & Verification Approval

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECKED	ARPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05	.03.08	WHEEL ASSEMBLY	SCALE 1:1





D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)

 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

Front.

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Fin-21-188

Dart Aerospace Lt	.a
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W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*						
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	_ Date: _	
				QA	: N/C Close	d:	_ Date: _	

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification	Annewal	Ammuoval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Page 1 of First Article Prototype Page 1 of First Article Prototype Prototyp	10)					Work Order: Part Number:		400
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FIRST ARTICLE INSPECTION CHECKLIST First Article Prototype Inspection Sheet Drawing Dimension Tolerance Dimension Accept Dimension Dimension Accept Dimension Accept Dimension Accept Dimension Accept Dimension Accept Dimension Dimension Dimension Accept Dimension Dimensio							Pa	ge 1 of 1
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